

Work Order ID 62574

Monday, October 04, 2010 2:27:27 PM



Page 1

Item ID: D412-698-023

Accept



Setup Start



Revision ID:

Stop



Item Name: Automatic Door Opener, LH/RH

Start Date: 10/4/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: 10-10-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| IIN D412-698 | Rev E |

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

S. 10/10/14

J. 10/10/13

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

C. 10/10/13 (3)

120 0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S. 10/10/14

(3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Setup Start

Revision ID:

Stop

Item Name: Automatic Door Opener, LH/RH

Start Date: 10/4/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 3.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130  | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D412-698-023 Location: _____ PPP Rev: <u>B</u> | | | | | | | | |
| 140  | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10/14/10 (3)

10/10/10
10-10-15
(3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62574

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH





Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| AN960JD516L  Washer | NAS1149D0516J | Purchased | No | | | 120 | Each | 99.0000 | 2 | 6 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST347 | | | | 99 | | | | | |
| | | | | | 112466 | | | 99 | | | | | |
| D3552-11  Door Prop | | Manufactured | No | | | 120 | Each | 10.0000 | 1 | 13 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST272 | | | | 10 | | | | | |
| | | | | | 58967 | | | 10 | | | | | |
| D3594-043  Floor Doubler Assembly, LH | | Manufactured | No | | | 120 | Each | 15.0000 | 1 | 13 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST234B | | | | 15 | | | | | |
| | | | | | 53712 | | | 4 | | | | | |
| | | | | | 54579 | | | 1 | | | | | |
| | | | | | 54838 | | | 10 | | | | | |
| D3594-044  Floor Doubler Assembly, RH | | Manufactured | No | | | 120 | Each | 14.0000 | 1 | 3 | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST | | | | 14 | | | | | |
| | | | | | 57746 | | | 14 | | | | | |

2

11/24/09

58967

57575 14
54838 20
3

57746

10/12/13 (3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 62574

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 3.00

Required Qty: 3.00

D3594-5
Door Doubler

Manufactured No

120 Each

17.0000

1

3

Location

Loc Qty

Loc Code

ST234A

17

57552

4

58968

13

120 Each

6.0000

2

D3622-1
Ball Stud

Manufactured No

Location

Loc Qty

Loc Code

ST074

6

59915

6

120 Each

879.0000

2

MS20426AD4-4
Rivet

Purchased No

Location

Loc Qty

Loc Code

ST316

879

15541

879

120 Each

89.0000

1

MS21073L5
nut plate

Purchased No

Location

Loc Qty

Loc Code

ST303

89

113660

89

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

| Qty -015 | Qty -023 | Part Number | Description |
|-------------|-------------|--------------|----------------------------|
| X | | D412-698-015 | DOOR SUPPORT KIT |
| | X | D412-698-023 | AUTOMATIC DOOR OPENER KIT |
| 2 | | D3200-1 | DOOR POST BLOCK |
| 2 | | D3200-3 | DOOR WEDGE |
| 2 | | D3201-1 | DOUBLER |
| 1 | | D3201-3 | ANGLE |
| 1 | | D3201-4 | ANGLE |
| | 1 | D3552-11 | GAS SPRING |
| | 1 | D3594-5 | DOOR DOUBLER |
| | 1 | D3594-043 | FLOOR DOUBLER ASSEMBLY, LH |
| | 1 | D3594-044 | FLOOR DOUBLER ASSEMBLY, RH |
| | 2 | D3622-1 | BALL STUD |
| | 1 | MS21073L5 | ANCHOR NUT |
| | 2 | MS20426AD4-4 | RIVET |
| 12 | | AN960JD10L | WASHER |
| | 2 | AN960JD516L | WASHER |
| 12 | | MS21042L3 | NUT (OR MS21042-3) |
| 12 | | MS24693-S277 | SCREW |

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Revision: E
Date: 08.05.01